

Work Order ID 82890

Tuesday, April 10, 2012 2:31:07 PM

82890

Page 1

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 4/10/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/20/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: *12-04-10* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *118366* 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

12-04-26

12-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/2/04/26					
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 7:40 Oven Temperature: 320°F Finish Time: 8:10	0.00 0.00							mk 12/04/27
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120989 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00							1 12/24/27

M117338

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: D4030-041	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Handwritten notes and stamps:
 1 X ~~0~~
 12/4/27
 82877
 1 0 BL 12-4-27
 12/4/30
 MF 12-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, April 10, 2012 2:31:11 PM

Page 1

Work Order ID: 82890

82890

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	10.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2581

Mounting Bracket

**

B82017 Ae 12.04.23 (2)

Location	Loc Qty	Loc Code
----------	---------	----------

WA005	10	
69739	1	
70766	2	
77045	1	
81253	6	

D3914-1

Manufactured No

100	Each	16.0000	2	2
-----	------	---------	---	---

D3914-1

Rib

**

Ae 12.04.23

Location	Loc Qty	Loc Code
----------	---------	----------

WA	2	
WA006	14	
81449	12	
82130	2	
82131	2	

D3914-7

Manufactured No

100	Each	4.0000	2	2
-----	------	--------	---	---

D3914-7

Rib

**

B82929 (2) Ae 12.04.23

Location	Loc Qty	Loc Code
----------	---------	----------

WA	-2	
81453	4	
WA006	6	

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100

Each

6.0000

3

3

D4016-3

Hinge Half, Lid

**

882523 (3) Ae 12.04.23

Location

Loc Qty

Loc Code

WA

6

81389

6

D4018-5

Manufactured No

100

Each

4.0000

9

9

D4018-5

Rib

**

882508 (9) Ae 12.04.23

Location

Loc Qty

Loc Code

WA005

4

80776

1

82699

3

D4020-5

Manufactured No

100

Each

5.0000

1

1

D4020-5

Mesh (350 Basket Long, Lid)

**

P 12-04-25

Location

Loc Qty

Loc Code

WA

5

81446

5

D4021-3

Manufactured No

100

Each

9.0000

1

1

D4021-3

Data Plate

**

P 12-04-25

Location

Loc Qty

Loc Code

WA

9

80897

9

881451 -> (1)

Tuesday, April 10, 2012 2:31:11 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/10/2012

Required Date: 4/20/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

9.0000

1

1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

Ac 12.04.23

Location

Loc Qty

Loc Code

WA

5

63720

0

81450

4

81701

1

WA006

4

81192

4

D4035-043

Manufactured No

100

Each

7.0000

1

1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

B81202 ① Ac 12.04.23

Location

Loc Qty

Loc Code

WA

3

81452

3

WA006

4

81203

4

D2728-3

Manufactured No

140

Each

0.0000

1

1

D2728-3

Dart Logo label

**

115000.

1

BA 12-4-07

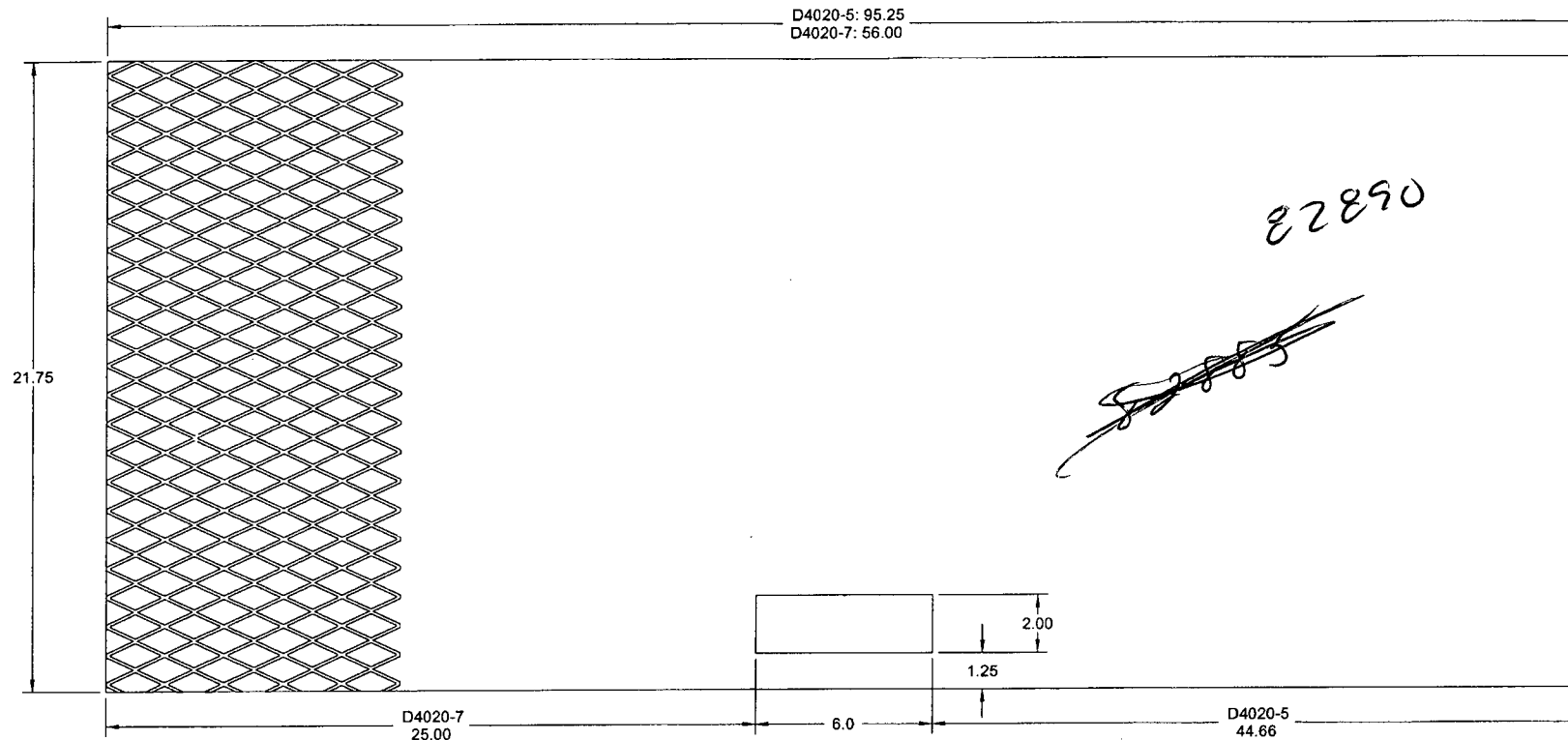
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NOTE: Date & initial all entries



9 D4020-5 MESH (350 BASKET LONG, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID)
(LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:

1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT -5: 0.80 lbs APPROX

-7: 4.49 lbs APPROX

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS

9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

RELEASED
2010-03-12
MAD

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D4020	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	350 BASKET MESH (BASE)	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

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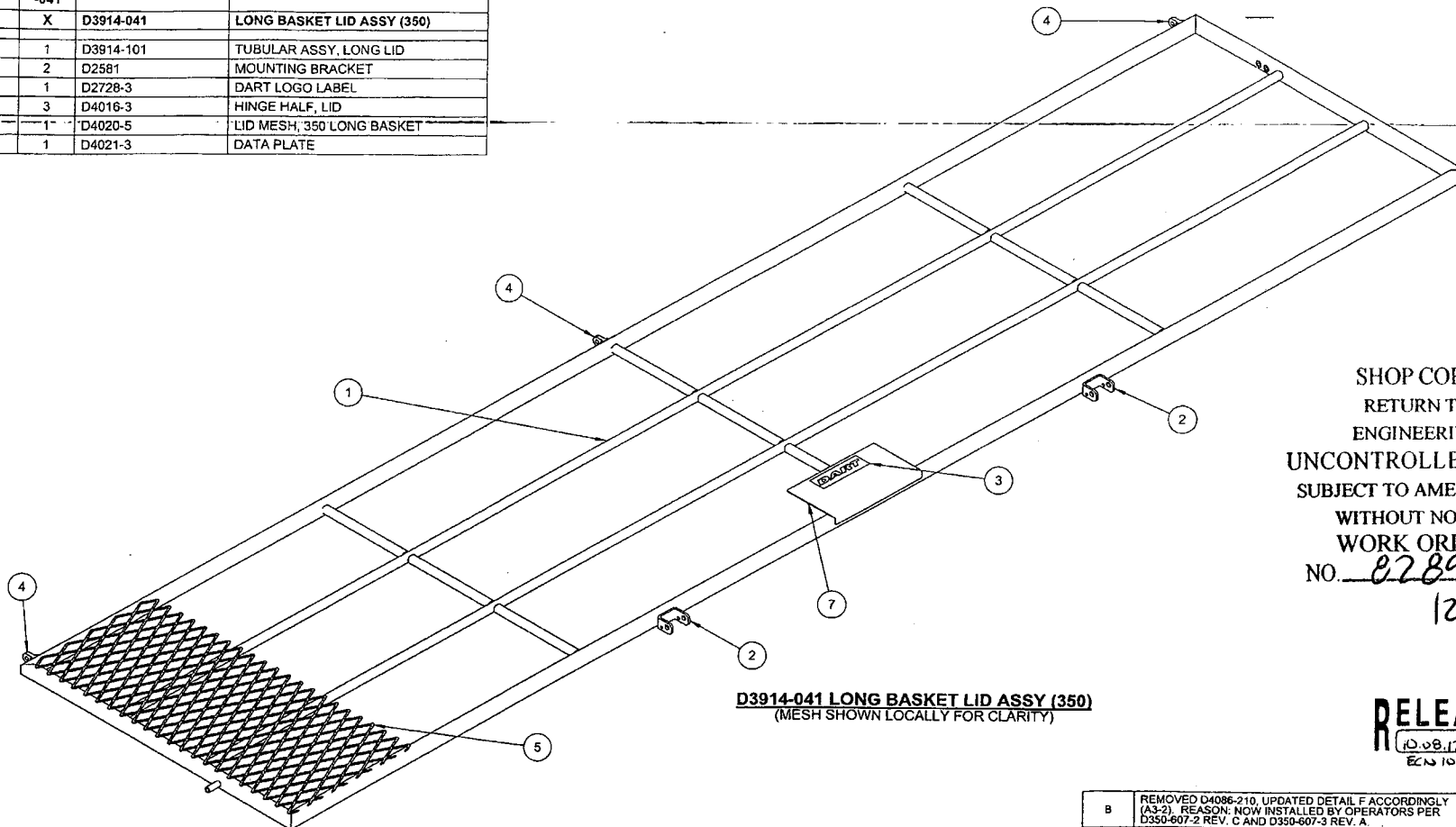
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82890 *MLW*
12/04/25

RELEASED
10.08.17 *JP*
ECS 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MLW</i>	D3914	SHEET 1 OF 4
APPROVED	<i>MLW</i>	TITLE	SCALE
DE APPR.	<i>MLW</i>	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

D4016-3
HINGE HALF, LID
REF

B8-2

D4016-3
HINGE HALF, LID
3 PL

D3914-101
TUBULAR ASSY

A5-2

8
4 PL

A1-2

D2581
MOUNTING BRACKET
2 PL

0.75-1.5

D3914-041 LONG BASKET LID ASSY (350) (MESH SHOWN LOCALLY FOR CLARITY)

D4020-5
MESH

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

DETAIL B D8-2

DETAIL C C3-2

0.06

D4016-3
HINGE HALF, LID
REF

8
3 PL

DETAIL D D1-2

D2728-3
DART LOGO LABEL

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

D4021-3
DATA PLATE
REF

VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	MD	D3914	SHEET 2 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
10.08.12 CP

82890

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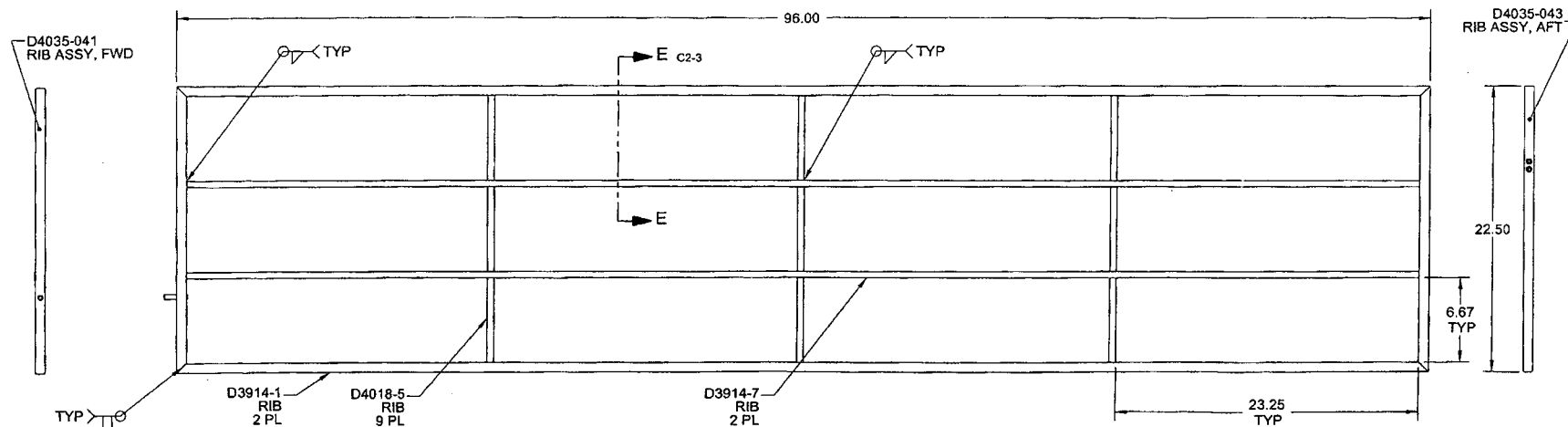
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



B D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	REV. B
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3914	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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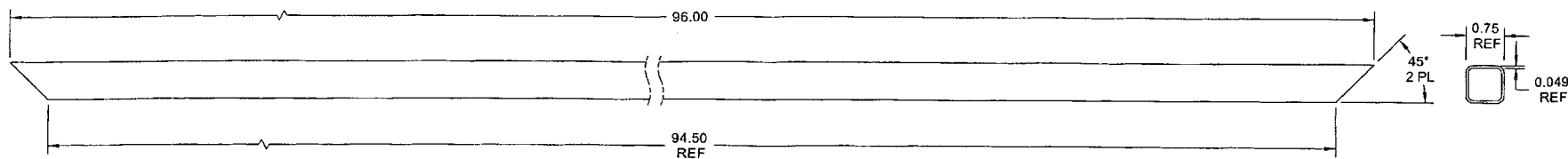
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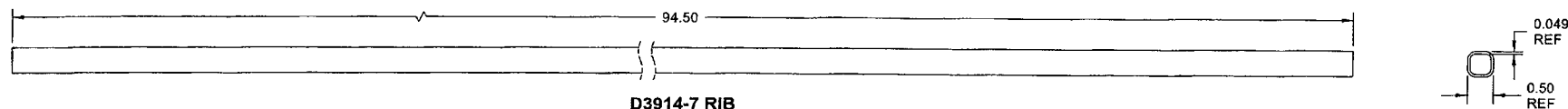
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02890



D3914-1 RIB



D3914-7 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	WD	TITLE	SCALE
DE APPR.	WD	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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